

Date: Thursday, 28/06/2007 2:26:10 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPLATE
Job Number	: 33220		
Estimate Number	: 10671		
P.O. Number	: <i>NIA</i>	Part Number	: D29701
This Issue	: 28/06/2007 S.O. No. : <i>NIA</i>	Drawing Number	: D2970 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>NIA</i> Type : SMALL / MED FAB	Drawing Revision	: A
Previous Run	: 33220	Material	: <i>NIA</i>
Written By	: <i>[Signature]</i>	Due Date	: 20/07/2007 Qty: 10 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est: B 01.06.07 Added Material and Tool number SM/EC Est Rev:C Now on Waterjet 07-06-27 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S20GA	1010/1025/A21/6aA SHEET
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Comment: Qty.: 0.3833 sf(s)/Unit Total : 3.8325 sf(s)

1010/1025/A21/6aA SHEET

20 Gauge .040"

Batch: *104921* *IB 07-07-05**10*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2970

Dwg Rev: *A*Prog Rev: *A*

2-Deburr if necessary

*IB 07-07-05**S47 07/07/07**(10)**10*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 07-07-05

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*En 07/07/06**counter**(X10)*

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Drawing Name: WEARPLATE

Job Number: 33220

Part Number: D29701

Job Number:



Seq. #: Machine Or Operation: Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Deburr and form on brake using DT8178

and DT8261 as per Dwg D2970

SB 07/02/17

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/07/17

NO

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M104846

BR/M 07-07-18

10

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FD

07/07/18

10

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FP 15

M/L 07/07/19

10K

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.07.19

Job Completion



U 07.07.19

Date: Wednesday, 6/27/2007 1:08:22 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPLATE
Job Number	: 33220		
Estimate Number	: 10671		
P.O. Number	:	Part Number	: D29701
This Issue	: 6/27/2007 S.O. No. :	Drawing Number	: D2970 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : PURCHASED PARTS	Drawing Revision	: A
Previous Run	:	Material	:
Written By	:	Due Date	: 7/20/2007 Qty: 10 Um: Each
Checked & Approved By	: <i>JA 07.06.28</i>		
Comment	: Est: B 01.06.07 Added Material and Tool number SM/E C		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: _____

Laser Cut per Dwg D2970

Material: AISI 1010-1025 or ASTM A36/A366 Series steel 20 gauge (0.040 thick)

Material release note required

Wetzel

*M10105206
3655*

2.0

D29701F

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Wearplate

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Deburr and form on brake using DT8178 and DT8261 as per Dwg D2970

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 6/27/2007 1:08:22 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 33220

Part Number: D29701

Job Number:



Seq. #:

Machine Or Operation.

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

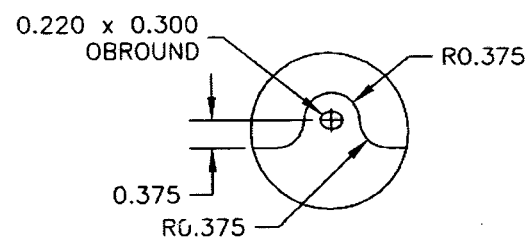
DART

QUALITY ASSURED

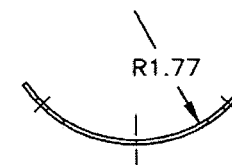
DESIGN	RF	DRAWN BY	RF	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	BELLEVUE, WA
DATE	00.03.10	DRAWING NO.	D2970	REV. A
TITLE	WEARPLATE	SHEET	1 OF 1	SCALE
A	00.03.10	NEW ISSUE		1:10

RELEASED
00.05.11

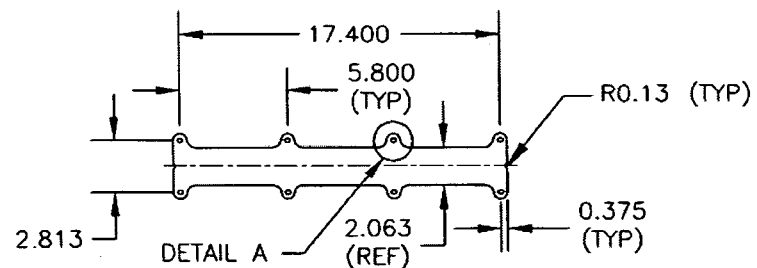
DETAIL A
SCALE 2:5



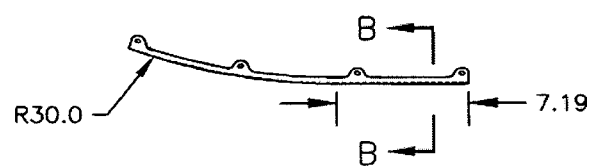
SECTION B-B
SCALE 2:5



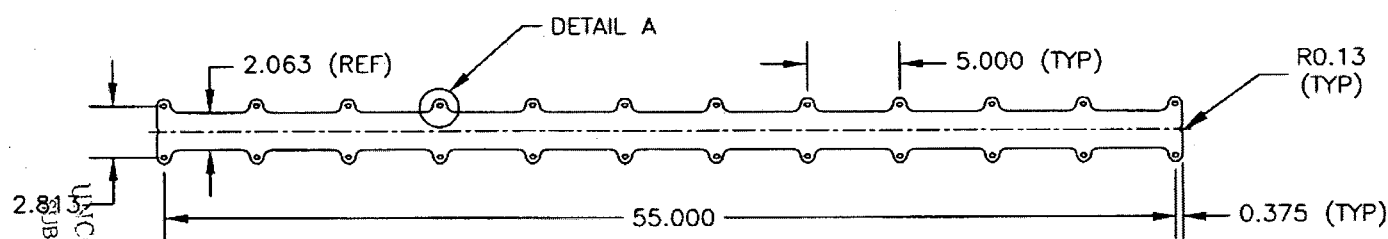
D2970-1 FLAT PATTERN



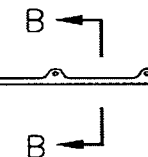
D2970-1 BENDING DETAIL



D2970-3 FLAT PATTERN



D2970-3 BENDING DETAIL



BREAK ALL SHARP EDGES 0.010 TO 0.020
MATERIAL: AISI 1010-1025 OR ASTM A36/A366 SERIES STEEL
20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 33220

